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RBT18560
Job Sheet 175144



Part No: RBT18560

Job Qty: 1 ea

Part Name: Engine Gearbox Seal Puller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 11/19/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/19/18	11/19/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	1 pcs	11/19/18	11/19/18	0.00	1.00	Small Fab		MLL DAS
120	QC	1 pcs	11/19/18	11/19/18	0.00	0.00	QC5		30
130	Packaging	1 pcs	11/19/18	11/19/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea	11/19/18	11/19/18	0.00	0.00			

Part Op
Descriptions: 110 - Assemble as per DWG. Sheet 1

DAS
21
9-89

DEC 19 2018

GA 145B

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
203 3408A94	Ball Plunger without thread locker	10 Ea (2 ea)	90-Start up Operation	5032756
65 90565A330	Tall Nut 1/2-20 UNF	5 Ea (1 ea)	90-Start up Operation	5032757
203 0069 91255A542	Button Head Socket Cap Screw 5/16-20 UNC x 1	10 Ea (2 ea)	90-Start up Operation	5032758
58 94846A525	Jam Nut 1/2-20	5 Ea (1 ea)	90-Start up Operation	5031248
34 NTA-815	Thrust Bearing	5 Ea (1 ea)	90-Start up Operation	5033969
145 B RBT18560-1	Puller	5 Ea (1 ea)	90-Start up Operation	5121979
RBT18560-11	Upright	10 Ea (2 ea)	90-Start up Operation	5133722
RBT18560-3	Ring	5 Ea (1 ea)	90-Start up Operation	5127022
RBT18560-5	Screw	5 Ea (1 ea)	90-Start up Operation	5128054
146A RBT18560-9	Cross Bar	5 Ea (1 ea)	90-Start up Operation	5131180
36 TRA-815	Bearing Washer	10 Ea (2 ea)	90-Start up Operation	5124410



Container No: S138697



Part: RBT18560

Job No: 175144

Serial No/Batch: S138697

Revision: 4

Inspector:

Exp Date:

Instructions:

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Date: 12/19/18

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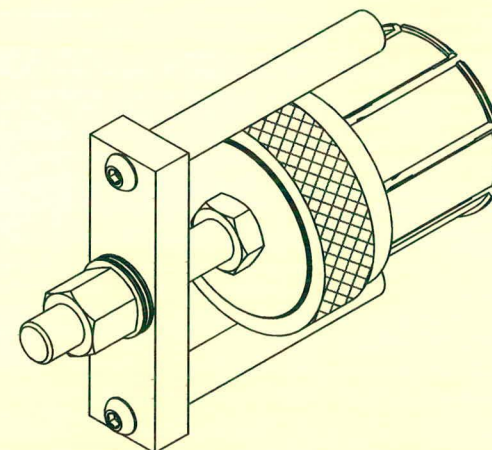
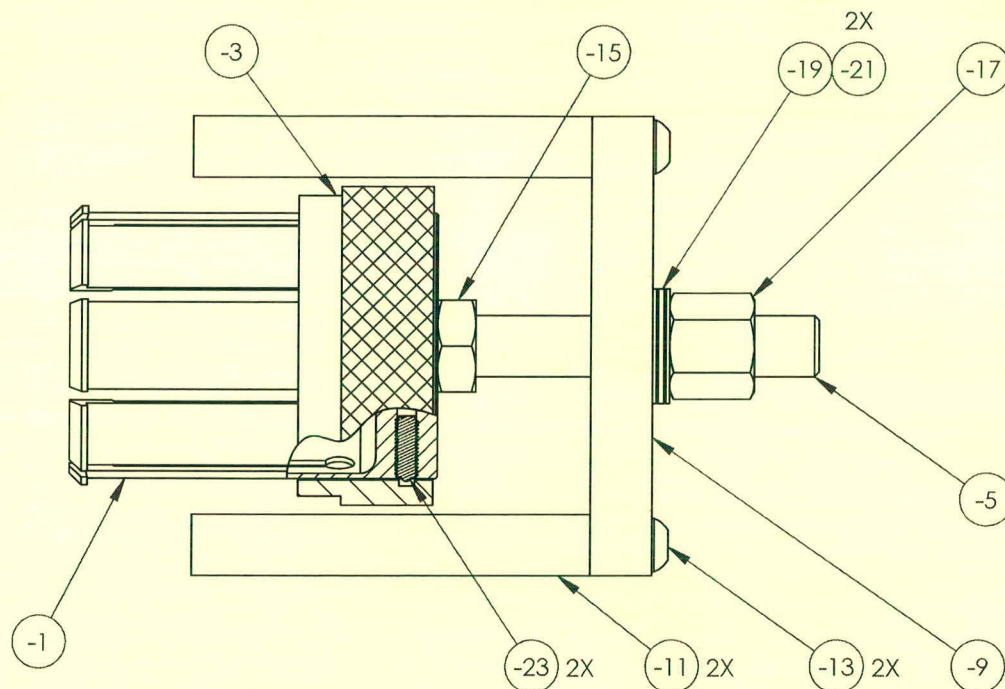
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3408A94	2	18	0
	90565A330	1	63	0
	91255A542	2	126	0
	94846A525	1	88	0
	NTA-815	1	10	0
	RBT18560-1	1	7	0
	RBT18560-11	2	0	0
	RBT18560-3	1	7	0
	RBT18560-5	1	8	0
	RBT18560-9	1	8	0
	TRA-815	2	20	0
Part Specifications				
Specifications could not be found.				

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TEO ATTACHED

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 PULLER SLOT HOLES INCREASED TO Ø1/4 & WALL THINNED FOR FLEXABILITY, -3 RING SHORTENED & GROVE MOVED TO ALLOW -1 PULLER TEETH TO FULLY EXPAND, -7 ILLUMINATED, -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003		
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE. RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG, AND COMBINED TWO FILES.	11/20/2007	WP	RW
3		CH'D -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE
4	15-0472	-9 CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG



NOTE:
1. USED ON BELL MODELS 206A, B, L1-L4.
SEAL #406-340-104-101

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PULLER	H13		2
			-3	1	RING	DOM		3
		B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMASTER-CARR # 98750A483) MODIFIED	4
			-9	1	CROSS BAR	1018/1020 CR		5
			-11	2	UPRIGHT	1018/1020 CR		6
		B/O	-13	2	BTN-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMASTER-CARR # 91255A542)	1
		B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMASTER-CARR # 94846A525)	1
		B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMASTER-CARR # 90565A330)	1
		B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
		B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
		B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMASTER-CARR # 3408A94)	1

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560	REV 4
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE	USED ON MODEL
CHECKED: DUERFELDT	SEE NOTE 1
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 2:3	DATE 5/2/2002
SHEET 1 OF 6	

